Work Order ID 116525

April-17-14 7:47:53 AM

116525

Item ID: D4837-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft Leg Assembly, RH

Start Date: 4/17/14 **Start Qty:** 2.00 *2*

Required Date: 5/02/14 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 14-04-17 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4837	A B C	M 14.06.18							
110		0.00							FF 14-07-23
110						2			
Small Fab	**Memo**	0.00							
Small Fab	ALIGN PILOT HOLES IN D4837-1 WITH PILOT HOLES IN D4869-1 AND D4808-041. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9959 AS PER DWG.								
120	QC5- Inspect part completeness to step on W/O	0.00	DAS 27 9-89						
120						2			
QC	**Memo**	0.00	14/7/23						
Quality Control									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 116525

April-17-14 7:47:53 AM

116525

Item ID: D4837-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Aft Leg Assembly, RH **Stop** *NS2*

Start Date: 4/17/14 **Start Qty:** 2.00 *Q*

Required Date: 5/02/14 **Req'd Qty:** 2.00 *Q*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						2		.08	14-07-31
Small Fab	**Memo**	0.00							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9959 A/R HYSOL BATCH: M128703								
140	QC5- Inspect part completeness to step on W/O	0.00	DAS 33 9-89 14/07/31	DAS 16 9-89 14/07/11					
140						(2)			
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: ST230	0.00	AUG 19 2014 St 230	DAS 06 9-89					
150									
Packaging	**Memo**	0.00							
Packaging									

145 Outsource 9 — Issue PO 25267 — P&L Printing > Engrave P/N as per drwg & QSI044 68 — C2 14/08/01 — 2x — DAS 28 9-89 — AUG 01 2014

146 Packaging — Receive & Inspect — 2x — SO 14-8-18.

147 QC5 — (2) 1408-18 — DAS 9 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4837-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft Leg Assembly, RH

Start Date: 4/17/14 **Start Qty:** 2.00 *2*
Required Date: 5/02/14 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MCJ 14-08-19

14-8-19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
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☐ Folio/Program
☐ Grain
☐ Hardware
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-17-14 7:47:56 AM

Work Order ID: 116525

116525

Parent Item: D4837-041

D4837-041

Parent Item Name: Aft Leg Assembly, RH

Start Date: 4/17/14 **Required Date:** 5/02/14

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A 14.01.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL20PB5-8		Purchased	No				Each	76.0000		8			
HL20PB5-8									**			FF 14-07-23	
Rivet													
HL32PB5-8				Location		Loc Qty		Loc Code					
				ST281	129865	66				8			
					M128110	6							
					M128579	60							
				ST284		10							
					M128429	10							
D4808-041		Manufactured	No				Each	0.0000		2			
D4808-041									**	2		FF 14-07-23	
Rod End Bearing Assembly					116516								
D4837-1		Manufactured	No		116526		Each	0.0000		2			
D4837-1									**	2		FF 14-07-23	
Strut													
D4869-1		Manufactured	No				Each	2.0000		2			
D4869-1									**			FF 14-07-23	
End Fitting, Eye													
				Location		Loc Qty		Loc Code					
				ST131	116536	2				2			
					116167	2							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

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☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-17-14 7:47:56 AM

Work Order ID: 116525

116525

Parent Item: D4837-041

D4837-041

Parent Item Name: Aft Leg Assembly, RH

Start Date: 4/17/14 **Required Date:** 5/02/14

Start Qty: 2.00 **Required Qty:** 2.00

HL86-5	Purchased	No		Each	133.0000	8

HL86-5

Collar

** FF 14-07-23

Location		Loc Qty	Loc Code	
ST280	129864	33		8
	M128110	33		
ST284		100		
	M128228	100		

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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General

☐ Bend
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25267

Purchase Order Date 7/31/2014
PO Print Date 8/1/2014

Order From : VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO KOC 2EO
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-931-1241

Ship To Contact
Ship To Phone
Ship Via: —
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: **$3.00**

11	116525	D4837-041 LEG ASSEMBLY	8/7/2014	2.00		$3.00	$6.00
			Yes				
			8/7/2014				

LASER MARKED

Line Total: **$6.00**

12	116501	D4801-042 LEG ASSEMBLY	8/7/2014	2.00		$3.00	$6.00
			Yes				
			8/7/2014				

LASER MARKED

Line Total: **$6.00**

13	71401-45	PROCUREMENT QUALITY CLAUSES	8/7/2014	1.00		$0.00	$0.00
			No				
			8/7/2014				

Quality Procurement Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A042 DART NOTIFICATION BY SUPPLIER

Note:

P&L PRINTING
19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

Invoice

Number: 7242

Date: August 12, 2014

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
25267		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4801-041	2.00	3.00	✔	6.00
Laser Metal Marking, D4878-042	1.00	4.00	✔	4.00
Laser Metal Marking, D4879-041	1.00	4.00	✔	4.00
Laser Metal Marking, D4879-041	1.00	4.00	✔	4.00
Laser Metal Marking, D4879-042	1.00	4.00	✔	4.00
Laser Metal Marking, D4879-042	1.00	4.00	✔	4.00
Laser Metal Marking, D4928-041	2.00	3.00	✔	6.00
Laser Metal Marking, D4928-042	1.00	4.00	✔	4.00
Laser Metal Marking, D4835-041	1.00	4.00	✔	4.00
Laser Metal Marking, D4837-041 √	2.00 √	3.00	✔	6.00 √
Laser Metal Marking, D4801-042	2.00	3.00	✔	6.00

Sub-Total	**$52.00**
13.00% on 52.00	6.76
Total	**$58.76**

Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You

P&L PRINTING

19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE Aug. 12, 2014

P.O NUMBER PO25267

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4801-041 LEG ASSEMBLY	2	ALL ITEMS HAVE BEEN LASER MARKED
D4878-042 LEG ASSEMBLY	1	
D4879-041 LEG ASSEMBLY	1	
D4879-041 LEG ASSEMBLY	1	
D4879-042 LEG ASSEMBLY	1	
D4879-042 LEG ASSEMBLY	1	
D4928-041 LEG ASSEMBLY	2	
D4928-042 LEG ASSEMBLY	1	
D4835-041 LEG ASSEMBLY	1	
D4937-041 LEG ASSEMBLY	2	
D4801-042 LEG ASSEMBLY	2	